

Date: Tuesday, 05/09/2006 10:35:05 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28410
 Estimate Number : 11265
 P.O. Number : *N/A*
 This Issue : 05/09/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 01/09/2006 Type : MACHINED PARTS
 Previous Run : 26085

Drawing Name : BAFFLE ASSEMBLY

Part Number : D3276042
 Drawing Number : D3276 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : *N/A*
 Due Date : 20/09/2006

Qty: 10 Um: Each

Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:A New Issue 05-12-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.040" thick
 (M6061T6S.040)
 Batch: *1119380* *MM 06 09 06*

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE *MM 06 09 06* (10)

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET *MM 06 09 06* (10)

4.0 QC8

SECOND CHECK

Comment: SECOND CHECK *MM 06 09 06* (10)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr *SAD 06:09:10* (10)

2-Roll as per Dwg D3276

SB 06/09/25

10

Date: Tuesday, 05/09/2006 10:35:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28410

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276 ,check with template DT8825

SB 06/09/2006 (10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 28410-25 (9) PRO

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YH 06/10/02 X 9

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06-10-02 (9)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 10 02 (9)

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s)

Pick:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

B 288012

FF 06-10-10 9

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal

B 288010

FF 06-10-10 9

Date: Tuesday, 05/09/2006 10:35:06 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28410

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3276

FF 06-10-10 9

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/12 9

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST-105

ml 06/10/13

x9

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/10/16

9

Job Completion



U 06-10-13

Pro-7

Date: Friday, 9/1/2006 12:17:32 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BAFFLE ASSEMBLY |
| Job Number : 28410 | |
| Estimate Number : 11265 | |
| P.O. Number : | Part Number : D3276042 |
| This Issue : 9/1/2006 S.O. No. : | Drawing Number : D3276 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 26085 | Material : |
| Written By : | Due Date : 9/20/2006 Qty: 10 Um: Each |
| Checked & Approved By : | |
| Comment : Est Rev:A New Issue 05-12-06 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S040 | 6061-T6 .040 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.040" thick
 (M6061T6S.040)
 Batch: _____

not here yet

PTC

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR
 Cut blank: 8.975" x 16.375" grain along 8.975"

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA498 and Dwg D3276
 Identify as D3276-1

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

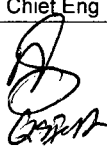
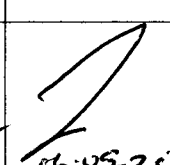
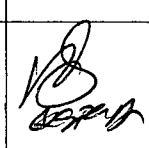
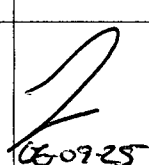
| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/18/16
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|--|---------------------------------|-----------------|--|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06-09-25 | 6-0 | 1 part SCRAP. Toggle was formed on the opposite side operator error |  | SCRAP: destroy. NO replace. | SRB 06/09/25 |  06-09-25 |  |  06-09-25 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:17:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28410

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3276

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276 ,check with template DT8825

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s)

Pick:

Qty Part Number Description Batch

27.0" D2464 Neoprene Seal

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:17:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28410

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal _____

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



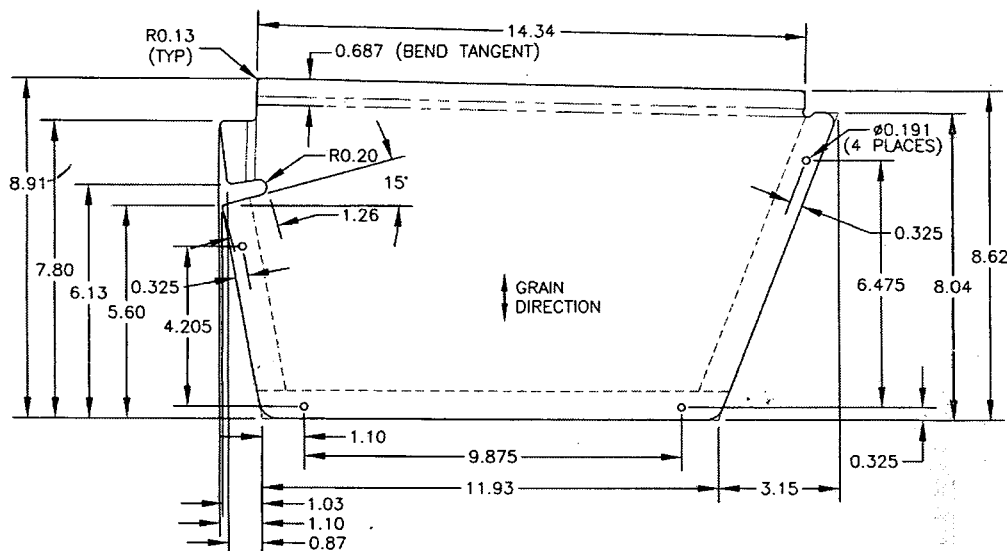
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

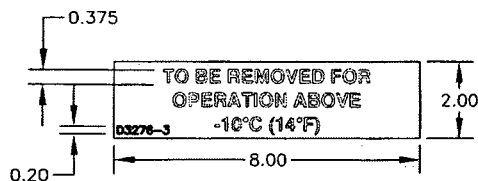
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3276-1 BAFFLE (FLAT PATTERN)

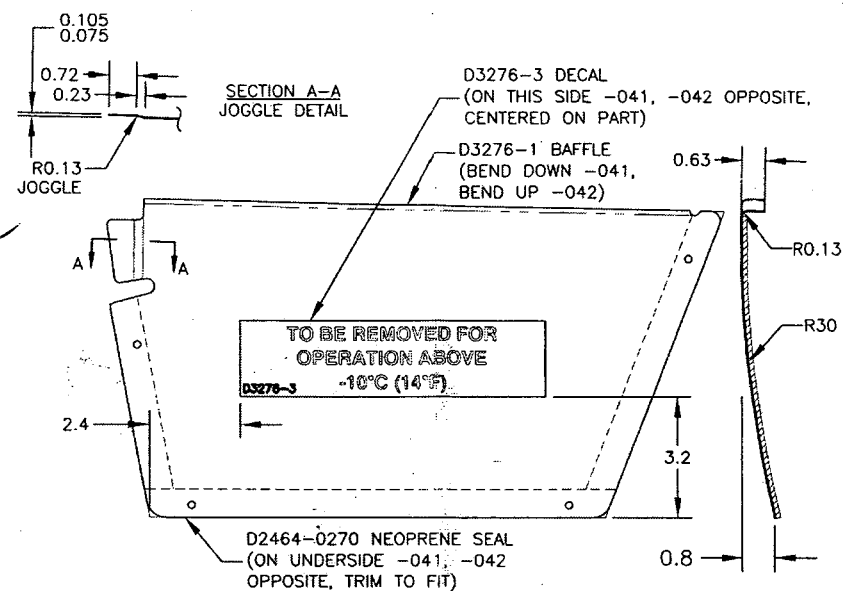
- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 28410



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED
05.01.07

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| | | |
|------------------|--------------------------|--|
| B | 05.01.25 | LABEL NOW -10°C; CURVE PART |
| A | 05.01.07 | NEW ISSUE |
| DESIGN CP | DRAWN BY CP | DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA |
| CHECKED H | APPROVED H | DRAWING NO. D3276 |
| DATE 05.01.25 | TITLE BAFFLE ASSEMBLY | REV. B SHEET 1 OF 1 SCALE 1:3 |